

# Work Order ID 76384

**\*76384\***

Page 1

November-11-11 9:23:27 AM

Item ID: D2989-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Basket Lid Assembly  
 Start Date: 11/11/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 21/11/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2989	Rev D

100 0.00  
**\*100\*** Large Fab  
 Large Fab Memo 0.00  
 Large Fab 1- assemble all ribs in DT9446 jig, weld as per dwg D2989  
 2- tack weld mesh on basket as per dwg D2989 using DT9446 jig  
 3- to locate hinges and shims use D2989-041, weld as per dwg D2989  
 A/R ER316 S.S. Rod Batch: 114649

110 0.00  
**\*110\*** QC9- Inspect visual per QSI004- Fusion Welds  
 QC Memo 0.00  
 Quality Control

Ppl 11.12.22 PTO

BE  
Ppl 11.12.22

1 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QS1005 4.3	0.00							
<b>*125*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

*5.11/12/23*

*Xp m-l 11/12/28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

**\*130\***

Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 &amp; Dwg D2989

1ST COAT

START TIME: 9:00OVEN TEMPERATURE: 400°FFINISH TIME: 9:30

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

Memo

0.00

Quality Control

*11/12/28**11-12-28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
<b>*150*</b>	wlo 76371	0.00				1	✓	12-1-4	
Packaging	Memo								
Packaging	D380-607-043								
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>		0.00							
QC	Memo								
Quality Control									

OK 12/01/05  
 MF  
 12-01-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

November-11-11 9:23:31 AM

Page 1

Work Order ID: 76384

**\*76384\***

Parent Item: D2989-043

**\*D2989-043\***

Parent Item Name: Basket Lid Assembly

Start Date: 11/11/2011

Required Date: 21/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM  
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC  
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC  
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D2221-1 Rib		Manufactured	No			100	Each	16.0000	1	1			
<b>*D2221-1*</b>													
**													

*Pl 11.12.22*

Location Loc Qty Loc Code

WA 16  
 71372 4  
 72297 12

✓ D2989-3 Rib		Manufactured	No			100	Each	4.0000	1	1			
<b>*D2989-3*</b>													
**													

*Pl 11.12.22*

Location Loc Qty Loc Code

WA 4  
 71551 1  
 72408 3

✓ D2989-4 Rib		Manufactured	No			100	Each	4.0000	1	1			
<b>*D2989-4*</b>													
**													

*Pl 11.12.22*

Location Loc Qty Loc Code

WA 4  
 71550 1  
 72409 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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# Picklist Print

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Page 2

Work Order ID: 76384

\*76384\*

Parent Item: D2989-043

\*D2989-043\*

Parent Item Name: Basket Lid Assembly

Start Date: 11/11/2011

Required Date: 21/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2989-5

Manufactured No

100

Each

9.0000

2

2

\*D2989-5\*

Rib

\*\*

lpl 11.12.22

Location

Loc Qty

Loc Code

WA

9

71222

9

2

D3182-1

Manufactured No

100

Each

6.0000

2

2

\*D3182-1\*

Hinge

\*\*

lpl 11.12.22

Location

Loc Qty

Loc Code

WA

6

71223

6

B 76557

2

D3442-3

Manufactured No

100

Each

11.0000

4

2

\*D3442-3\*

Shim

\*\*

lpl 11.12.22

lpl 11.12.22

Location

Loc Qty

Loc Code

WA005

11

70671

11

B 77476

3

D3827-041

Manufactured No

100

Each

9.0000

1

\*D3827-041\*

Rib Assembly (Inboard)

\*\*

lpl 11.12.22

Location

Loc Qty

Loc Code

WA

9

72083

3

72729

6

1

November-11-11 9:23:31 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2989-043 PAR #: \_\_\_\_\_ Fault Category: Large Fat NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/12/22	100	SEE ATTACHED EMAIL.  RC: LOA. JIG ONLY CONTROL BASE OF LID.	<u>11/12/22</u>	ADD QTY(1) D3442-3 AT BOTH END- OF BASKET LID AS SHOWN IN ATTACHED PHOTO.	<u>11-12-22</u>	<u>11/12/23</u>	<u>11/12/22</u> <u>@11043</u>	<u>11/12/23</u>

NOTE: Date & initial all entries

# Picklist Print

November-11-11 9:23:31 AM

Page 3

Work Order ID: 76384

\*76384\*

Parent Item: D2989-043

\*D2989-043\*

Parent Item Name: Basket Lid Assembly

Start Date: 11/11/2011

Required Date: 21/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3832-5 Manufactured No

100 Each

5.0000

1 1

\*D3832-5\*

Mesh (Lid)

\*\*

*Pl 11.12.22*

Location

Loc Qty

Loc Code

WA

5

71302

2

73638

3

①

D3833-5 Manufactured No

100 Each

48.0000

2 2

\*D3833-5\*

Mesh (Lid End)

\*\*

*Pl 11.12.22*

Location

Loc Qty

Loc Code

WA

48

67461

48

②

D3838-041 Manufactured No

100 Each

4.0000

1

\*D3838-041\*

Rib Assembly (Basket Lid, LH)

\*\*

*Pl 11.12.22*

Location

Loc Qty

Loc Code

WA

4

71744

1

72414

3

①

D3838-042 Manufactured No

100 Each

4.0000

1

\*D3838-042\*

Rib Assembly (Basket Lid, RH)

\*\*

*Pl 11.12.22*

Location

Loc Qty

Loc Code

WA

4

71740

1

72415

3

①

November-11-11 9:23:32 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**D2989-043 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 76384 M.C.J

11/11/11

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

**RELEASED**  
08/11/18 M.P.

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2989	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.24		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

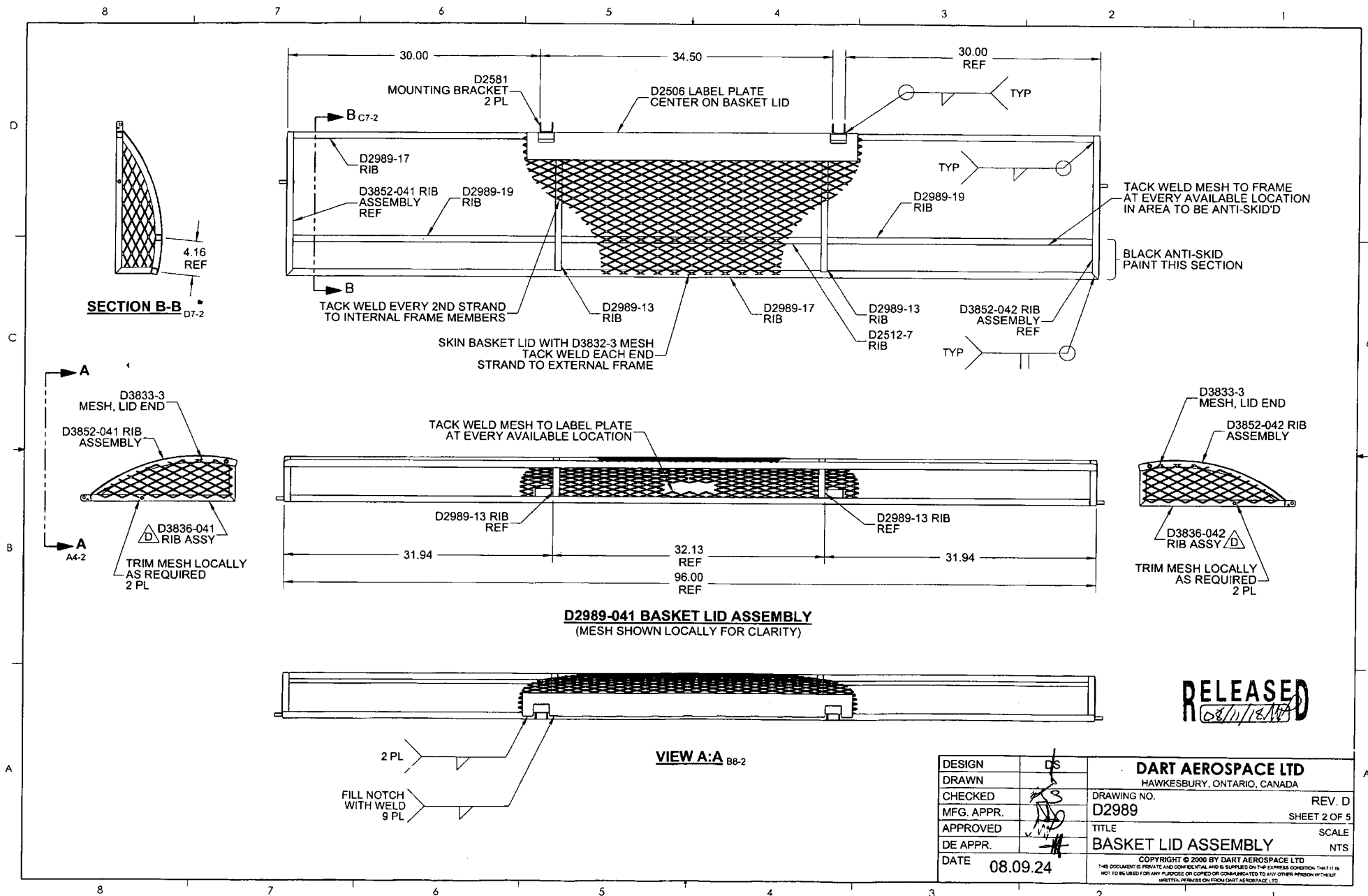
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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RELEASED  
08/11/13

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. D
MFG. APPR.	DD	D2989	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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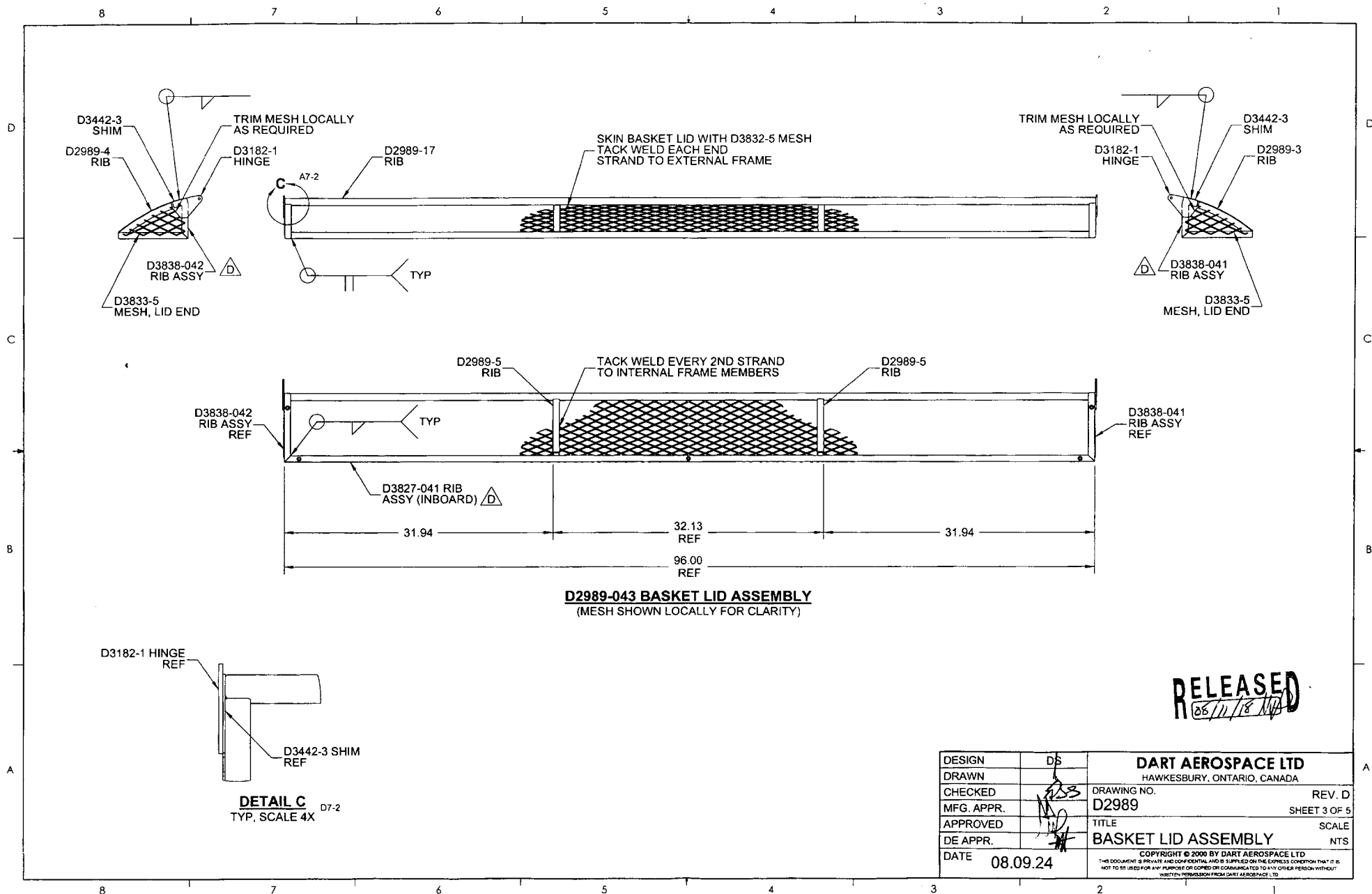
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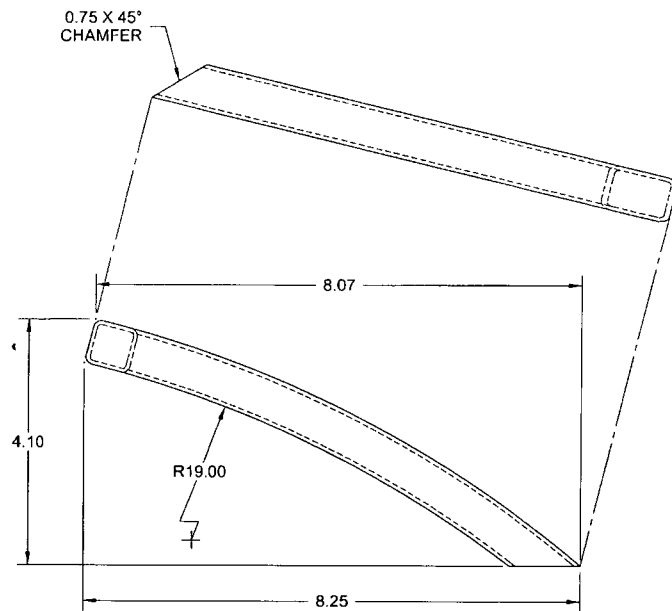
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

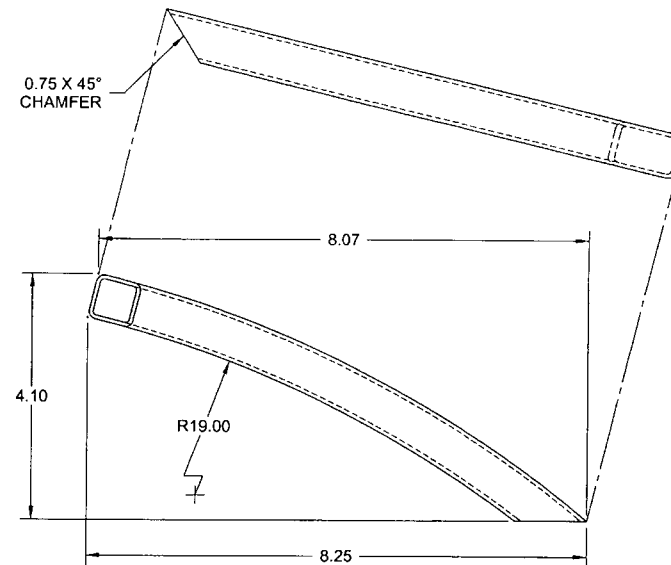
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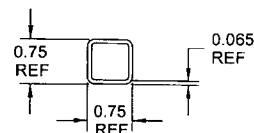


**D2989-3 RIB**



**D2989-4 RIB**

- NOTES:
- 1) MATERIAL: D3166-3 BASKET HOOP
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;



**TYPICAL SECTION VIEW**

**RELEASED**  
08/11/18

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET LID ASSEMBLY</b>	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

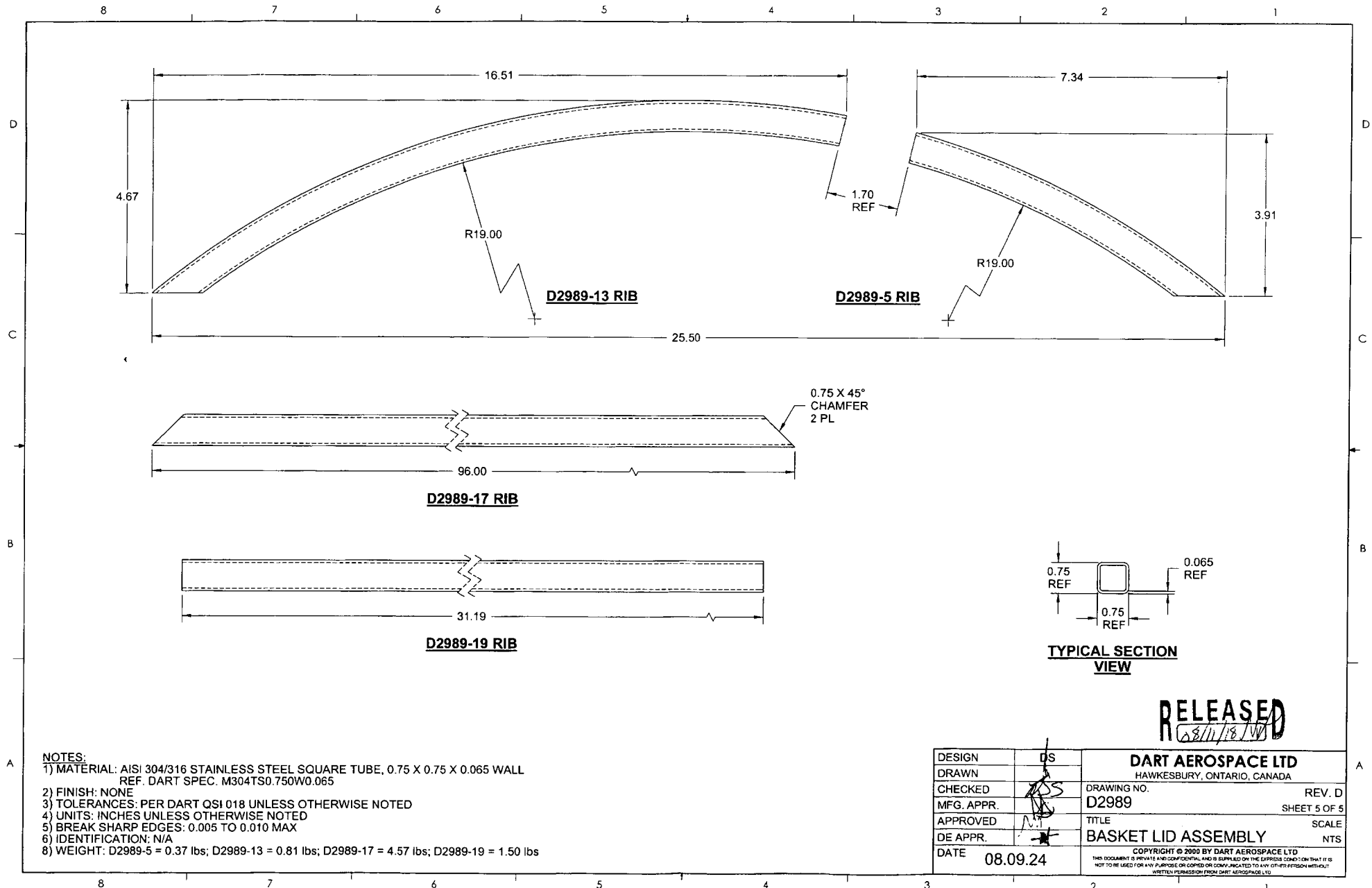
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

76384



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## Marc Bellavance

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**From:** David Shepherd <dshepherd@dartaero.com>  
**Sent:** Wednesday, December 21, 2011 5:29 PM  
**To:** 'Marc Bellavance'  
**Cc:** 'Downing, Eric'; 'Smith, Pat'; 'Lacelle, Linda'; 'Duval, David'  
**Subject:** RE: W/O NCR on D350-607-043 Basket

Hi Marc,

This deviation is acceptable. Moving forward, have we looked at the tooling to make sure it is appropriate so that this doesn't happen again?

David

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**From:** Marc Bellavance [<mailto:mbellavance@dartaero.com>]  
**Sent:** December-21-11 7:51 AM  
**To:** Shepherd, David  
**Cc:** Downing, Eric; Smith, Pat; Lacelle, Linda; Duval, David  
**Subject:** W/O NCR on D350-607-043 Basket

Good morning David,

Please see attached pictures. I've also attached D2989 drawing for convenience.

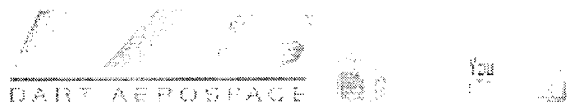
Carl is currently working on a D350-607-043 Basket. The D2989-041 and D2989-043 Basket Lids are not quite the same length and would require an extra D3442-3 Shim to be welded at both ends of D2989-043 to ensure proper fit/functionality. Personally, I don't think that this is a problem but I'm not authorized to okay such deviation... Therefore, are you okay with this?

### **Marc Bellavance**

*Technical/Shop Support*

T. 613-632-5200 | C. 613-676-0992 | F. 613-632-9311

1270 Aberdeen Street, Hawkesbury, Ontario, Canada, K6A 2K7



**Product Documentation: Verify Revision Status/Download [HERE!](#)**

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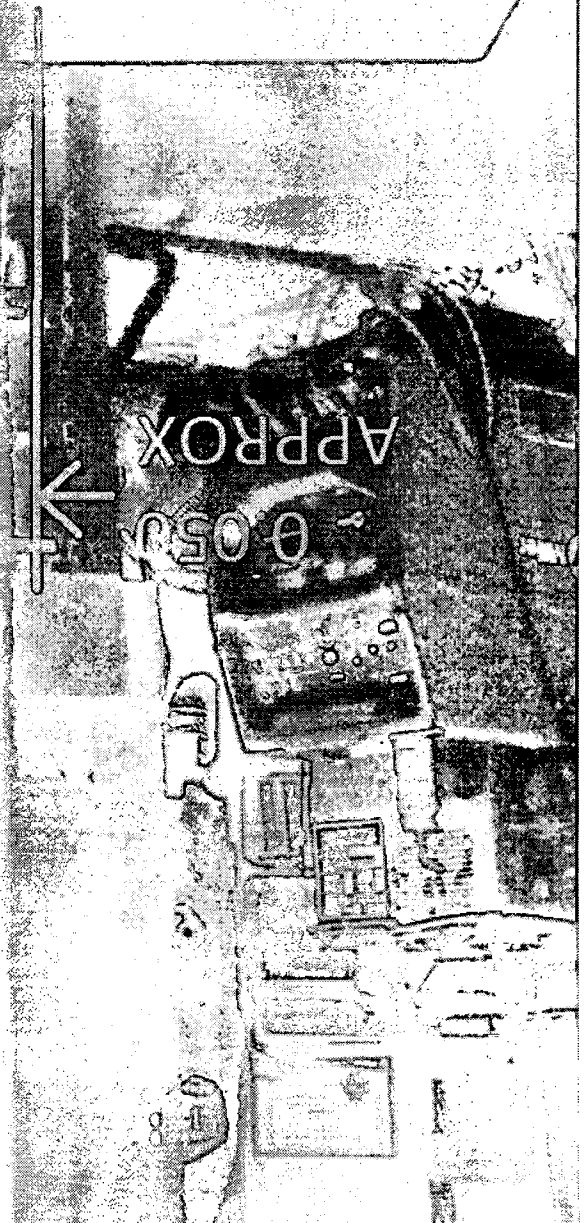
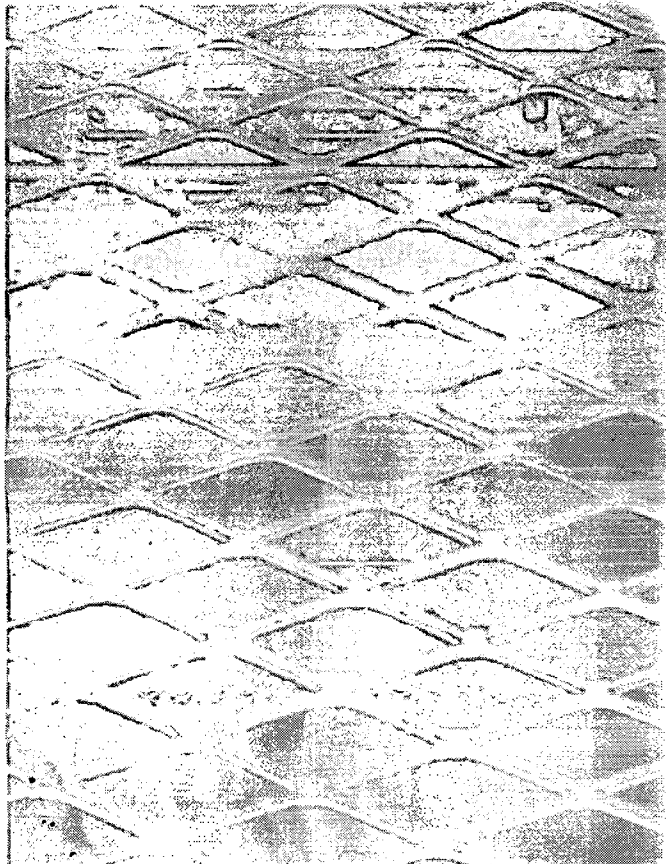
Please consider your environmental responsibility before printing this e-mail.

Viewed from top of Basket.

2989-041

2989-043

APPROX  
- 0.050



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